

Date: Tuesday, 15/07/2008 4:12:00 PM
 User: Julie Lecocq

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	SADDLE FITTING, FWD (OUTBOARD/INBOARD)		
Job Number	40515		Part Number	D2572		
Estimate Number	10531		Drawing Number	D2572 REV E		
P.O. Number			Project Number	N/A		
This Issue	15/07/2008	S.O. No.		Drawing Revision	E	
Prsht Rev.	NC		Material			
First Issue	/ /	Type	MACHINED PARTS	Due Date	08/08/2008	Qty: 10 Um: Each
Previous Run	40085					
Written By						
Checked & Approved By	<u>JUL 08.7.16</u>					
Comment	Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101005	Saddle Billet	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) 7075-T7351 8.25X5.0X2.5 Make from D6101-005 billet for D2572 Ensure that grain is along 5.00" length Batch No: <u>B34874</u>	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. <u>Y0515</u> Double check by: <u>Y.A</u>	
		1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.	
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2571 & D2572	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/07/2008 4:12:00 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 40515

Part Number: D2572

Job Number:



Seq. #: Machine Or Operation:

Description :

4.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 08/08/15

(10)

5.0 QC8

SECOND CHECK



Comment: SECOND CHECK

8.15 08/08/19

(10)

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M 08/08/19

(10)

7.0 POWDER COATING

POWDER COATING



M 108523



(10X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 11-45

11-45

OVEN TEMPERATURE: 322°

322°

FINISH TIME: 12-15

12-15

M-1 08/08/19

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

BR 08/08-19

(10)

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST432

AS 08/08/20 (X10)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



08/08/21

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



-MF 08-08-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 40515
Description: Saddle, Fwd Inboard	Part Number: D2572
Inspection Dwg: D2572 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.441	.440	.439			
B	1.745	1.755		1.750	1.750	1.749"	1.750"		
C	3.495	3.505		3.499	3.500	3.501"	3.501"		
D	1.745	1.755		1.750	1.750	1.749"	1.750"		
E	7.990	8.010		8.006	8.006	8.005"	8.005"		
F	0.490	0.510		.499	.500	.504"	.504"		
G	0.257	0.262		.259	.259	.260	.260		
H	0.375	0.380		.378	.378	.378	.378		
I	0.490	0.510		.499	.500	.500	.500		
J	1.174	1.184		1.179	1.178	1.178	1.178		
K	0.558	0.578		.565	.570	.569	.568		
L	1.174	1.184		1.179	1.178	1.178	1.178		
M	1.490	1.500		1.492	1.494	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.499	2.500		
O	3.869	3.879		3.871	3.871	3.874	3.874		
P	0.115	0.135		.126	.126	.126	.127		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.249	.249	.250	.251		
S	0.115	0.135		.135	.134	.134	.134		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.236	.237	.239	.239		
W	0.115	0.135		.133	.132	.131"	.132"		
X	0.307	0.312		.307	.307	.307"	.307"		
Y	0.760	0.765		.761	.766	.760"	.760"		
Z	0.352	0.372		.367	.366	.366"	.368"		
AA	0.470	0.530		.500	.500	.500	R.500"		
AB	0.615	0.635		.626	.636	.630"	.630"		
AC	0.053	0.073		.063	.063	.063"	.063"		
AD	0.240	0.260		.241	.241	.243	.242		
AE	1.375	1.395		1.390	1.391	1.388	1.388		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.248	.246	.249	.250		
AI	2.000	2.020		2.005	2.006	2.005	2.005		
AJ	0.023	0.043		.032	.033	.033"	.033"		
Accept/Reject									

Measured by:	<i>gml</i>
Date:	08/08/13

Audited by:	<i>84</i>
Date:	08/08/13

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>28</i>	<i>gml</i>

DART AEROSPACE LTD	Work Order: 40515
Description: Saddle, Fwd Inboard	Part Number: D2572
Inspection Dwg: D2572 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	X5	X6	X7	X8	By	Date
A	0.438	0.443		.439	.439"	.439"	.439"		
B	1.745	1.755		1.750"	1.750"	1.750"	1.750"		
C	3.495	3.505		3.501	3.501"	3.501"	3.501"		
D	1.745	1.755		1.750"	1.750"	1.750"	1.750"		
E	7.990	8.010		8.005"	8.005"	8.005"	8.005"		
F	0.490	0.510		.501"	.505"	.501"	.507"		
G	0.257	0.262		.258"	.258"	.258"	.258"		
H	0.375	0.380		.376"	.377"	.377"	.377"		
I	0.490	0.510		.502"	.502"	.502"	.503"		
J	1.174	1.184		1.182"	1.182"	1.182"	1.182"		
K	0.558	0.578		.570"	.566"	.568"	.569"		
L	1.174	1.184		1.180"	1.180"	1.181"	1.181"		
M	1.490	1.500		1.499"	1.499"	1.496"	1.496"		
N	2.495	2.505		2.502"	2.502"	2.502"	2.502"		
O	3.869	3.879		3.874"	3.874"	3.874"	3.874"		
P	0.115	0.135		.126"	.136"	.126"	.125"		
Q	0.115	0.135		.127"	.127"	.127"	.127"		
R	0.240	0.260		.252"	.251"	.251"	.250"		
S	0.115	0.135		.135"	.132"	.130"	.130"		
T	0.178	0.198		A.188"	A.188"	R.188"	A.188"		
U	2.940	2.980		2.959"	2.959"	2.959"	2.959"		
V	0.230	0.250		.243"	.244"	.244"	.244"		
W	0.115	0.135		.133"	.135"	.133"	.135"		
X	0.307	0.312		.307"	.309"	.310"	.309"		
Y	0.760	0.765		.760"	.760"	.760"	.760"		
Z	0.352	0.372		.370"	.370"	.372"	.372"		
AA	0.470	0.530		A.500"	A.500"	R.500"	R.500"		
AB	0.615	0.635		.631"	.631"	.630"	.630"		
AC	0.053	0.073		.063"	.063"	.063"	.063"		
AD	0.240	0.260		.240"	.252"	.250"	.252"		
AE	1.375	1.395		1.386"	1.386"	1.387"	1.385"		
AF	0.115	0.135		.135"	.135"	.135"	.135"		
AG	0.240	0.280		.280"	.280"	.280"	.280"		
AH	0.240	0.260		.249"	.253"	.251"	.253"		
AI	2.000	2.020		2.005"	2.005"	2.005"	2.005"		
AJ	0.023	0.043		.033"	.033"	.033"	.033"		
Accept/Reject									

Measured by:	J.F.	Audited by:	88
Date:	08/08/15	Date:	08/08/10

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	JL

DART AEROSPACE LTD	Work Order:	40515
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				X9	210	3	4		
A	0.438	0.443		0.438"	0.439"	0.439"			
B	1.745	1.755		1.750"	1.750"				
C	3.495	3.505		3.501"	3.501"				
D	1.745	1.755		1.750"	1.750"				
E	7.990	8.010		8.005"	8.005"				
F	0.490	0.510		0.505"	0.505"				
G	0.257	0.262		0.258"	0.258"				
H	0.375	0.380		0.372"	0.371"				
I	0.490	0.510		0.503"	0.503"				
J	1.174	1.184		1.182"	1.182"				
K	0.558	0.578		0.570"	0.570"				
L	1.174	1.184		1.181"	1.181"				
M	1.490	1.500		1.496"	1.496"				
N	2.495	2.505		2.502"	2.502"				
O	3.869	3.879		3.871"	3.871"				
P	0.115	0.135		0.126"	0.126"				
Q	0.115	0.135		0.127"	0.127"				
R	0.240	0.260		0.250"	0.250"				
S	0.115	0.135		0.135"	0.135"				
T	0.178	0.198		0.188"	0.188"				
U	2.940	2.980		2.959"	2.959"				
V	0.230	0.250		0.244"	0.244"				
W	0.115	0.135		0.135"	0.135"				
X	0.307	0.312		0.310"	0.310"				
Y	0.760	0.765		0.760"	0.760"				
Z	0.352	0.372		0.372"	0.372"				
AA	0.470	0.530		0.500"	0.500"				
AB	0.615	0.635		0.630"	0.630"				
AC	0.053	0.073		0.063"	0.063"				
AD	0.240	0.260		0.255"	0.255"				
AE	1.375	1.395		1.387"	1.387"				
AF	0.115	0.135		0.135"	0.135"				
AG	0.240	0.280		0.280"	0.280"				
AH	0.240	0.260		0.253"	0.253"				
AI	2.000	2.020		2.005"	2.005"				
AJ	0.023	0.043		0.023"	0.023"				

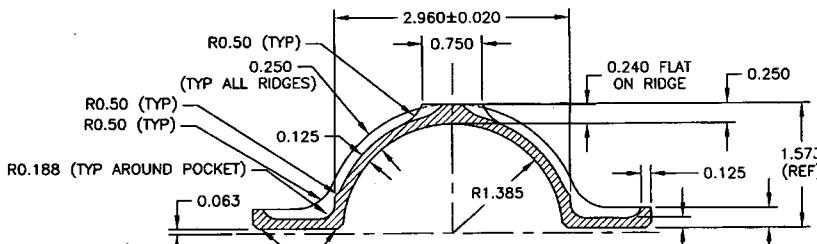
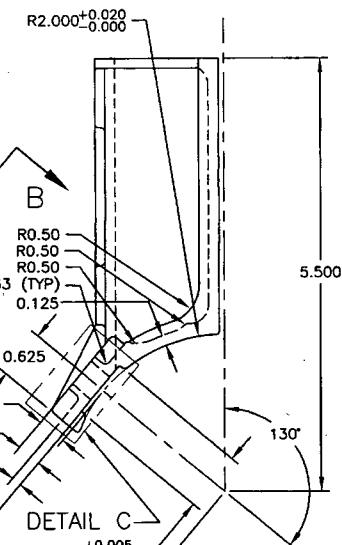
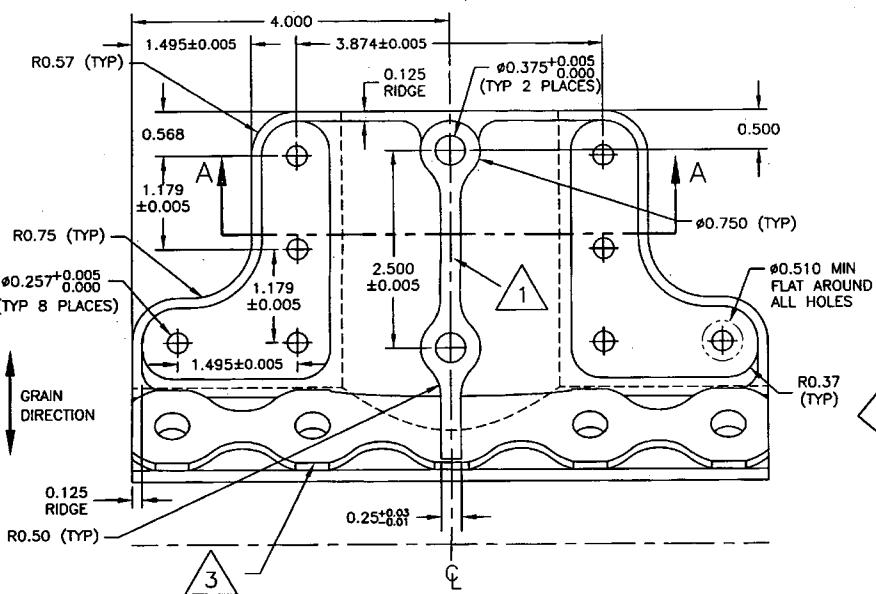
Accept/Reject

Measured by:	J.F.	Audited by:	85
Date:	08/08/15	Date:	08/08/14

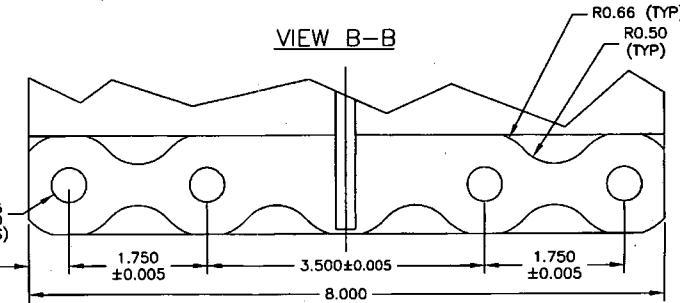
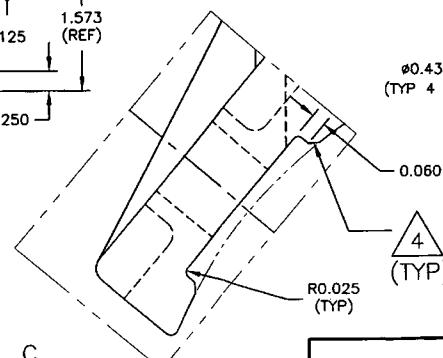
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	20 JLM

RELEASED

05.12.06



SECTION A-A
DETAIL C
SCALE 2:1



NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C)
- E

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DART AEROSPACE LTD.

DESIGN	DRAWN BY	REV. E
DS	PH	DART DART AEROSPACE LTD. HAWKSBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2572
DATE	TITLE	SHEET 1 OF 1
05.07.13	INNER FWD SADDLE	2:3

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SUBJECT TO AMENDMENT
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WORK ORDER
NO. 40515